

Work Order ID 76851

Tuesday, November 22, 2011 10:26:40 AM

76851

Page 1

Item ID: D3017-11

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: cap

Stop

NS2

Start Date: 11/22/2011 Start Qty: 40.00

40

Cust Item ID:

Required Date: 11/29/2011 Req'd Qty: 40.00

40

Customer:

Reference:

Approvals:

Process Plan:

WMC

Date:

11-11-22

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D3017

Rev B

100

0.00

100

FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3017

4130-050

Dwg Rev: *B*

Prog Rev: *B*

2-Deburr if necessary

11-11-24

GA

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Memo

0.00

Quality Control

11-11-24

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 76851

76851

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Item ID: D3017-11

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Item Name: cap

Stop ***NS2***

Start Date: 11/22/2011 Start Qty: 40.00

40

Cust Item ID:

Required Date: 11/29/2011 Req'd Qty: 40.00

40

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

QC8- Inspect parts - second check

0.00

120

QC

Memo

0.00

Quality Control

130

Packaging

0.00

130

Packaging

Memo

0.00

Packaging

Identify and bag with light oil (Vactra oil #2), then Stock Location SWA

140

QC21- Final Inspection - Work Order Release

0.00

140

QC

Memo

0.00

Quality Control

counter
(x62)

SP 11-11-25

11/11/28 DJ

11-11-25
(62)

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Picklist Print

Tuesday, November 22, 2011 10:26:39 AM

Page 1

Work Order ID: 76851

Parent Item: D3017-11

Parent Item Name: cap

Start Date: 11/22/2011

Required Date: 11/29/2011

Start Qty: 40.00

Required Qty: 40.00

Comments: IPP Rev:A 08-04-14 now on water jet DD verified by:EC IPP RevB: as per revB DD
verified by:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M4130NS.049 4130 Sheet .049		Purchased	No			100	sf	6.0000	0.004	0.1684211			

Location

Loc Qty

Loc Code

MAT020

6

11612

6

11612

11-11-27

62

W/O:		WORK ORDER CHANGES					
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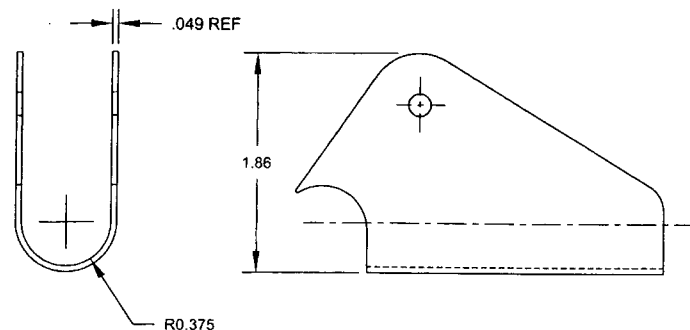
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

8 7 6 5 4 3 2 1

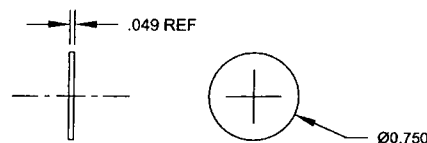
D



D3017-7 LUG
BENDING DETAIL
MAKE FROM D3017-7F

C

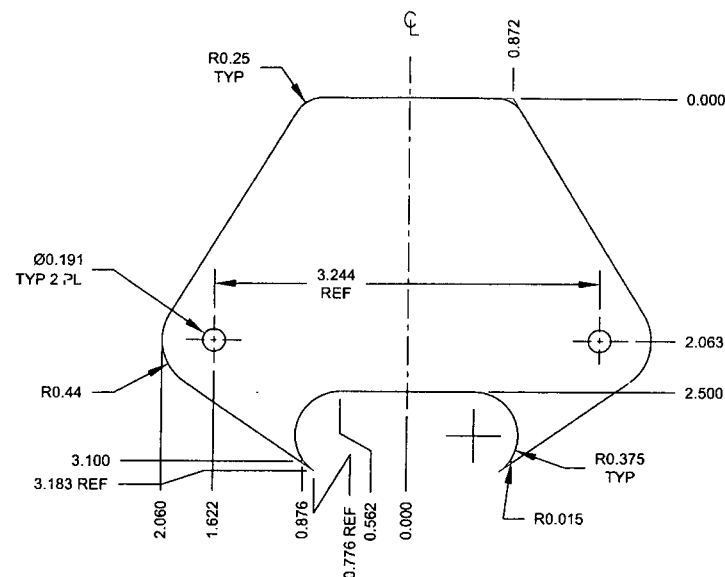
B



D3017-11 END CAP

NOTES:

- 1) MATERIAL: AISI 4130N SHEET, 18 GAUGE (M4130N-S049)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: -7: 0.12 lbs; -11: 0.01 lbs.



D3017-7F FLAT PATTERN
PART IS SYMMETRIC
ABOUT CENTERLINE

#7685

RELEASED
2010-02-02

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3017	SHEET 4 OF 4
APPROVED		TITLE	SCALE
DE APPR.		BACK FRAME ASSEMBLY	NTS
DATE	10.01.13	<small>COPYRIGHT © 2001 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS UNDERSTANDING THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD</small>	

8 7 6 5 4 3 2 1

A

A

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